










## Profiled Milling Cutter Ø125 Z22

### A2-040

The tool is ground with a profile wheel, the dressing is performed directly on the machine. By interpolation paths and CAM (radial relief) are calculated automatically. The below mentioned grinding time is based on a material removal of about 0.2mm.



### 1. Cycletime for Production

Workpiece:									
Diameter 125,8 mm, Z22									
Material HSS									
Operations									
Feed [mm/Min]	2000	80	200	150	150	2000	200	150	150
Power [kW]		1	1	1	2		1	1	2
Cutting feed [m/s]		32	32	32	32		32	32	32
Used wheels		—	1	1	1		1	1	1
Grinding time [s]	20	60	960	45	60	20	960	45	60
Total cycle time	37 Min 10								

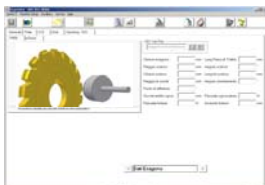
The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1: Ø30 shank 6mm



### 3. Machine and Software Requirements



Machines: 5 axes CNC grinders : **GEMINI**dmr AWL  
 Control: Fanuc 31i  
 Coolant: Synthetic Oil, pressure 6 - 7 bar  
 Software: Quinto 5

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